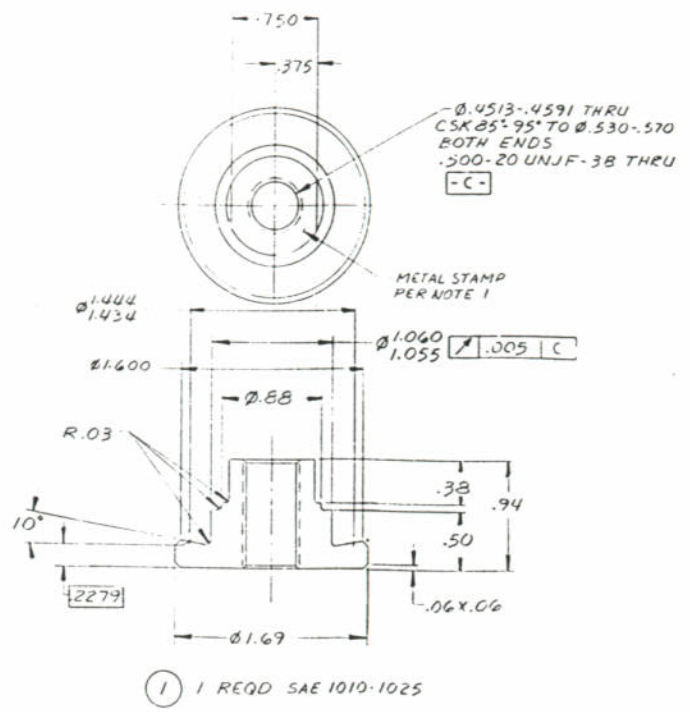
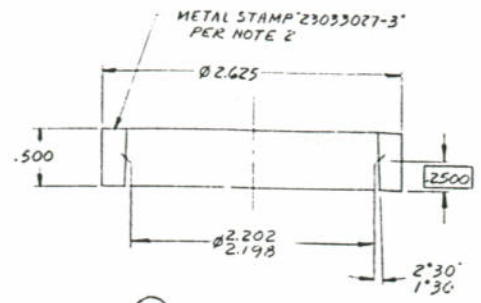
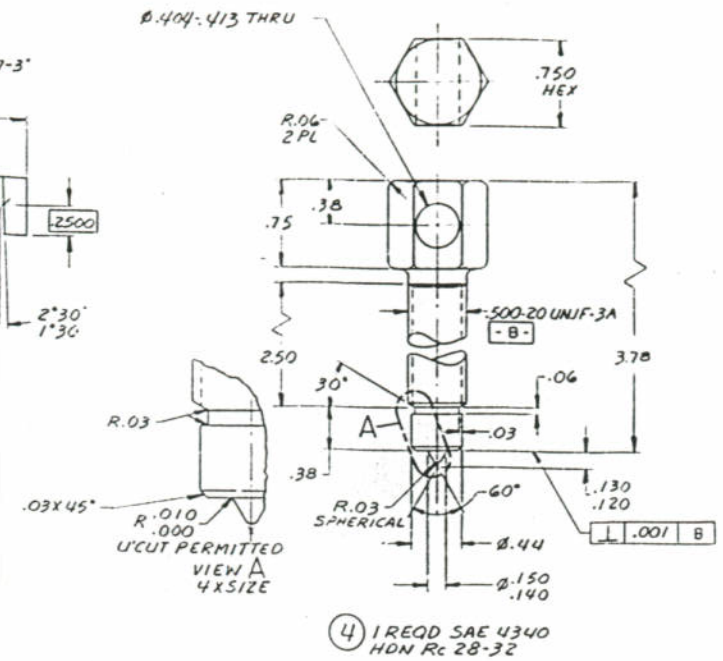
REVISIONS					
ZONE	LTR	DESCRIPTION	DATE	APPROVED	
B2	A (1)	REVISED TITLE	3-4-72	DTL	



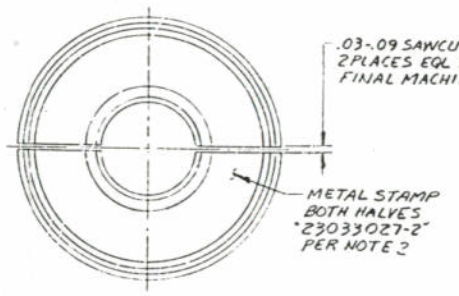
(1) 1 REQD SAE 1010-1025

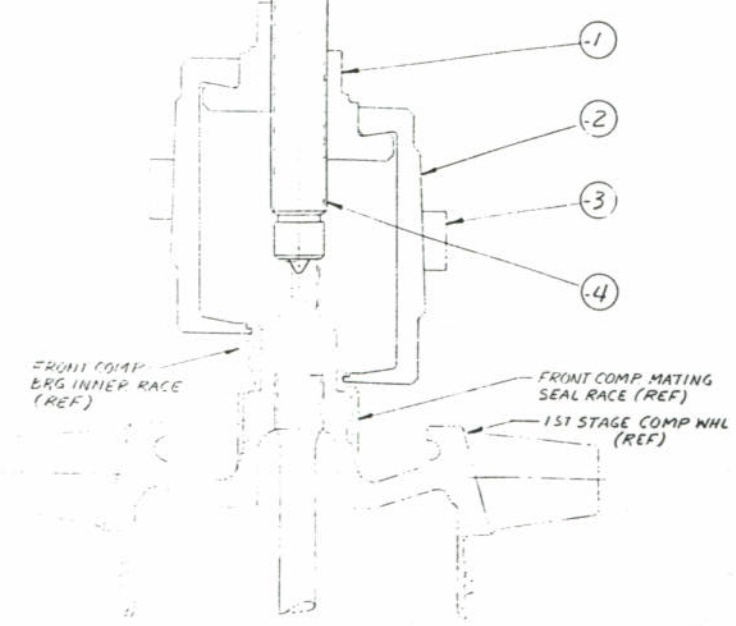


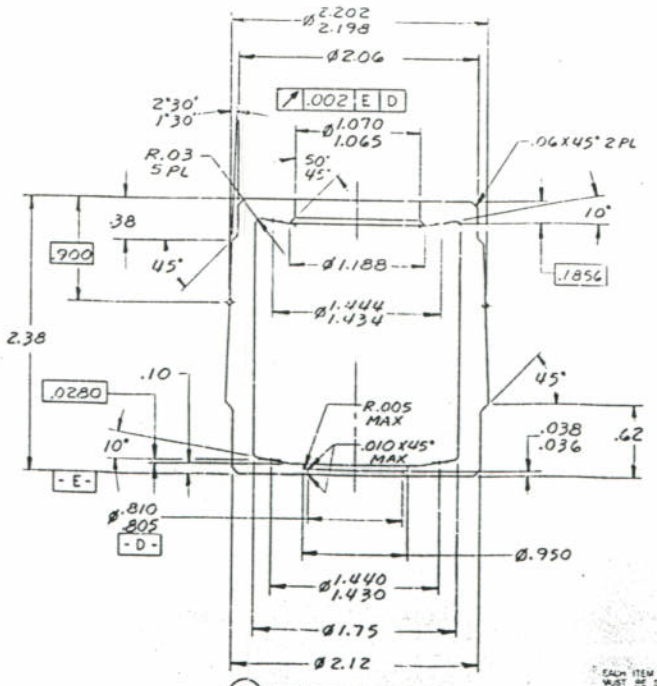
(3) 1 REQD SAE 4340
HDN Rc 36-40



(4) 1 REQD SAE 4340
HDN Rc 28-32







(2) 1 REQD SAE 4340
HDN Rc 36-40

ITEM NO	REQD	NOMENCLATURE OR DESCRIPTION	MATL SPEC NUMBER	MATL SPEC DESIGNATION	MATERIAL OR NOTES
4	1	PRESSURE SCR			STL
3	1	RING			STL
2	1	DOG			STL
1	1	SUPPORT			STL

FOR PART IDENTIFICATION ITEM NUMBERS SEE EXPLODED ASSEMBLY DRAWING OF THIS PACK DRAWING, EXCEPT WHERE A DIFFERENT NUMBER IS USED FOR IDENTIFYING MARKING ON MFR.

NOTES:

WORK AS SPECIFIED IN LOCATION SHOWN WITH ⌀ IS HIGHLIGHTED BY THE FOLLOWING OF THE SAME DETAIL RELEASED BY THE TOOL NUMBER WITH LAST CHANGE LETTER REVISION STAMP IN TRIANGLE

2. MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8-3/16 FIGURES
3. BLACK OXIDE ITEMS 1, 2, 3, AND 4 PER AMS 2485

These tool drawings are furnished in accord with the terms of the Allison Tools Reference contract. The apparent intent of drawings are to be maintained in the contents of the furnished and shall not be disclosed to any other parts without specific written consent of Allison Gas Turbine Division, G.M.C.

FILE COPY

BREAK SHARP EDGES .020 UOS (A1)

APPLICATION: SEE SEPARATE PARTS LIST

UNLESS OTHERWISE SPECIFIED: SEPARATE TRUE POSITION CALLOUTS MAY BE USED SEPARATELY REGARDLESS OF DATUM REFERENCE

UNLESS OTHERWISE SPECIFIED
TOL ON ANGLES ± 1°
TOL ON 2 PLACE DECIMALS ±.02
TOL ON 3 PLACE DECIMALS ±.010

MATL: SEE ITEM

HEAT TREAT AND HARDNESS: SEE ITEM

SURFACE TREAT: SEE NOTE

DRAWING DATE	65-2-16	
DRAFTSMAN	Edward Kitz	
CHECKER	Frank Fenton	
APPROVED	Hayden	
METALLURGY		
ENGR 1	J K FARRELL	
ENGR 2	D M AVERS	
FINAL	E C HEALEY	
WELD OR BRAZE		
INSPECTION	-	

EACH ITEM THROWAWAY (STRAIGHT) MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DASH NUMBER IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG

UOS ALL DIMENSIONS ARE IN INCHES

THIRD ANGLE PROJECTION

DRAWING PRACTICE	LOCAL SPECS (REF)
SURFACE TEXTURE	
SCREW THREADS	
GENERAL SPECIFICATIONS	SPEC SUMMARY

Allison GAS TURBINE DIVISION General Motors Corporation Indianapolis, Indiana

TITLE: PULLER, BEARING AND MATING SEAL RACE-FRONT COMPR.

MODEL (FIRST MODEL) 250-C20R

SIZE E | FSCM NO. 63005 | DWG. NO. 23033027 | SHEET

SCALE 2/1

23033027 1

REF- 23005023, T159064